








Deriv 55277



Work Order ID 53299

October 29, 2009 2:17:00 PM

Page 1

Item ID:	PB67-43001-193	Accept		Setup	Start	
Revision ID:	C					
Item Name:	D-Pad Base				Stop	
Start Date:	10/30/2009	Start Qty:	24.00		Cust Item ID:	
Required Date:	11/16/2009	Req'd Qty:	24.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>WKF</u>	Date:	<u>09-10-29</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	C								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg PB67-43001-193								
	Dwg Rev: <u>E</u>								
	Prog Rev: <u>E</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

HB 10-1-5

(54)

10/06/07 54

HB 10-1-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: PB67-43001-193

Accept



Setup Start



Revision ID: C

Stop



Item Name: D-Pad Base

Start Date: 10/30/2009 Start Qty: 24.00



Cust Item ID:

Required Date: 11/16/2009 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	27 8/10/10/08			counter (54)	0		
130 Small Fab Small Fab	Small Fab Memo 1- c'sink as per dwg. 2- Install nutplate with rivet.	0.00 0.00							Ep 10/01/12 (54)
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	27 8/10/10/12			counter (54)	0		

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Work Order ID 53299

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Item ID: PB67-43001-193

Accept



Setup Start



Revision ID: C

Stop



Item Name: D-Pad Base

Start Date: 10/30/2009 Start Qty: 24.00



Cust Item ID:

Required Date: 11/16/2009 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 446B

0.00



Packaging

Memo

0.00

Packaging

10-1-12

542

JL

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/12

MF 10-1-12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

October 29, 2009 2:16:59 PM

Page 1

Work Order ID: 53299

Parent Item: PB67-43001-193RevB1

Parent Item Name: D-Pad Base

Start Date: 10/30/2009

Required Date: 11/16/2009

Comments:

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

CCR264SS3-3

Purchased

No

130

Each

65.0000

96.0000



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

65

111548

38

111827

1

112314

26

M6061T6S.125

Purchased

No

100

sf

104.7952

0.2779



6061-T6 .125 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

104.7952

110062

1.85

111642

19.592

112476

32

112567

51.3532

MS21075L3

Purchased

No

130

Each

175.0000

48.0000



Nutplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

175

112991

175

25/10/01/11
M113068
152X
M113539 644

12-10-1-5

112567
25/10/01/11

104

M113539 4X

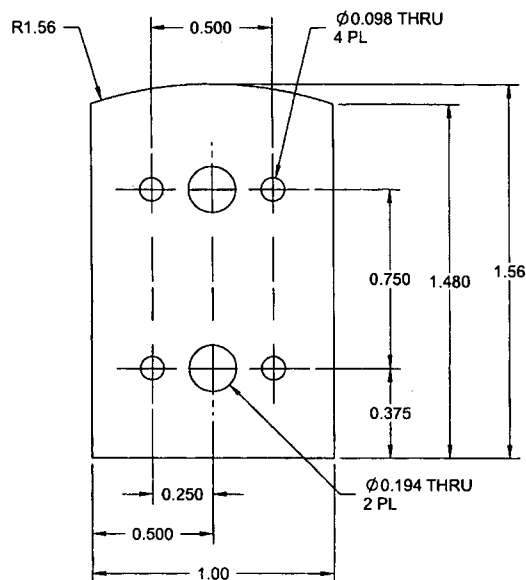
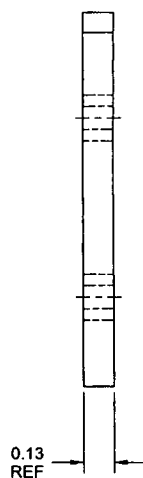
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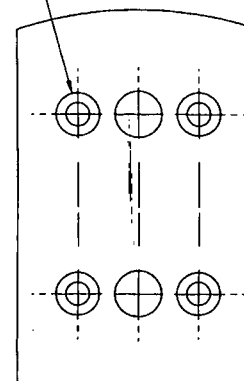
NOTE: Date & initial all entries



B67-43001-193F D-PAD BASE

53299

Ø0.180 X 100°
4 PL



B67-43001-193 D-PAD BASE
(MAKE FROM B67-43001-193)

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 25 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.03.03
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C SHEET 1 OF 1	
DRAWN	AS			
CHECKED	AS	DRAWING NO.	SCALE	
MFG. APPR.	AS	B67-43001-193		
APPROVED	AS	TITLE	NTS	
DE APPR.	N/A	D-PAD BASE		
DATE	09.03.03	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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